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United States
Department of
Agriculture

Food Safety
and Inspection
Service

Meat and Poultry
Inspection
Program

July 1983

Issuances of the Meat and Poultry Inspection Program

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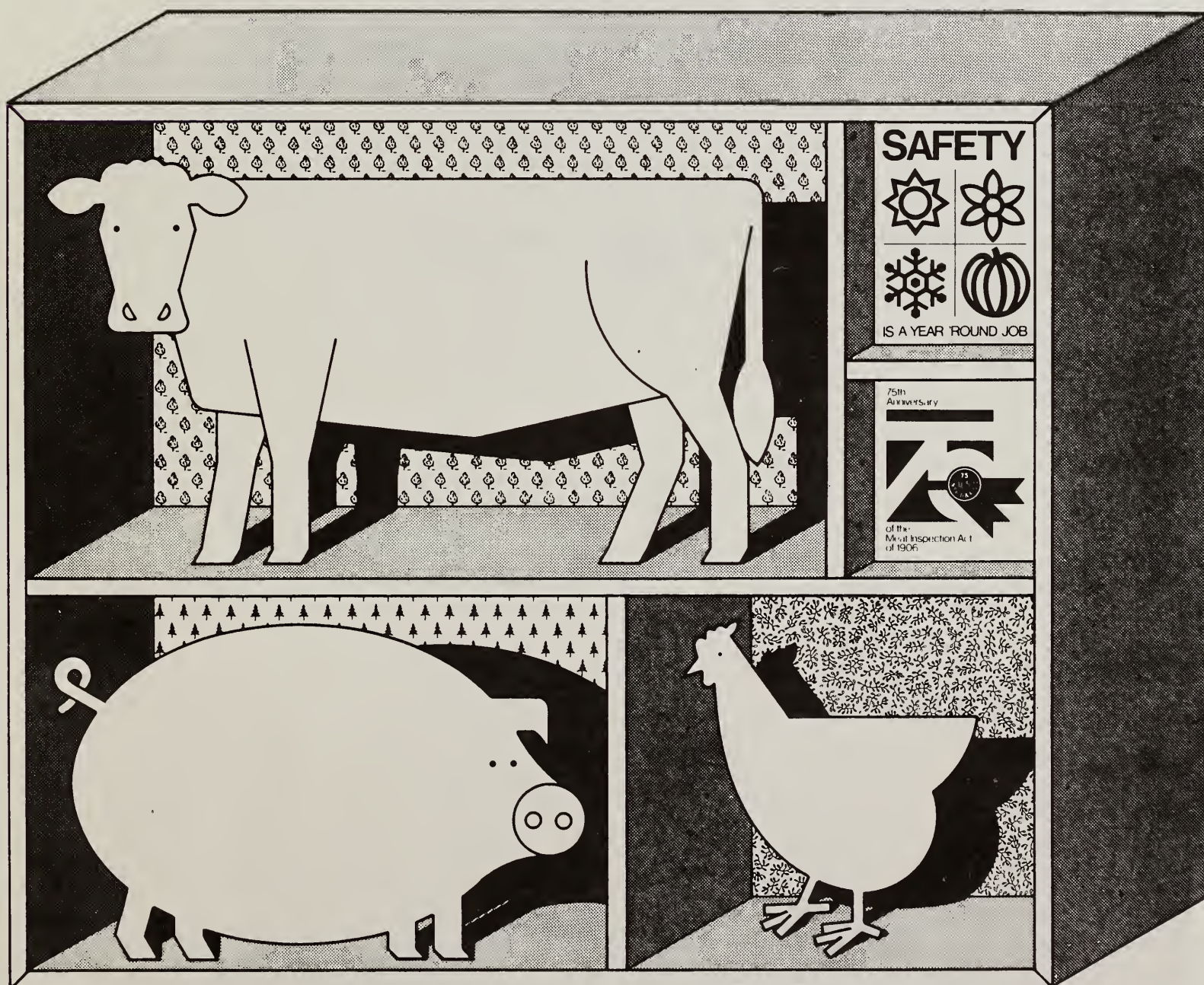


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Change 83-7 Meat and Poultry Inspection
Manual

UNITED STATES DEPARTMENT OF AGRICULTURE
Food Safety and Inspection Service
Meat and Poultry Inspection
Washington, D.C. 20250

Meat and Poultry Inspection Manual

Date: July 1983

Change Number: 83-7

MAINTENANCE INSTRUCTIONS

Remove Page	Insert Page	Numbered
278 and 279	278 and 27	83-7
286 and 287	286, 286a and 287	83-7

Pen-and-Ink Changes

Page 180a, first column, line 10, should read "(c) Animal Food."

Page 260a, first column, under (i) Fresh/frozen, line 4 and 6, form number 131 should be changed to 150.

Page 260a, first column, under (ii) Processed, line 9, should read MP Form 150.

IMPORTS

SPECIAL REQUIREMENTS

Subpart 27-A

(Regs: M-301, 316, 327; P-Subpart A, T)

27.1 DEFINITIONS

For purposes of this Part, the following definitions will apply.

(a) General

(1) Automated Import Information System (AIIS). A centralized, computer based, data processing system which maintains all available information relating to imported product and assigns inspection levels and procedures based upon established sampling rules and compliance history.

(2) Inspection Assignment.

Instructions generated by the AIIS detailing the type(s) of inspection to be performed (TOI), sampling status of the product lot(s) (tightened, normal, skip lot step 1, skip lot step 2) and, where applicable, random sampling data.

(3) Laboratory Sample. A product sample (for other than residue analysis) submitted for one or more of the following reasons:

- a. Previous non-compliance
 - b. Lack of product history
 - c. To confirm inspector's suspicions
 - d. Specific Program needs
 - e. Maintain product compliance history.
- Samples collected in categories a through d above may require that the lot be placed on "sample and hold."

(4) Sample and hold. Retention of product lots pending receipt of certain "laboratory sample" analytical results.

(5) Type of Inspection (TOI). A series of code letters appearing on the Inspection Assignment directing import inspection personnel to perform specific types of inspection and/or sampling, based upon type of product and compliance history.

(6) Code Marks. Markings which identify a lot or a distinct portion of a lot either by type of meat (hinds, fores, shanks, etc.) or a production run (day or period of day).

(7) Consignee. The person or party to whom the imported product is destined.

(8) Consignor. The person or party who sold the imported product to the consignee.

(9) Sampling Inspection. That type of inspection in which samples consisting of one or more units of production are selected at random from the completed lot and examined for one or more quality characteristics. Based upon this examination certain assumptions are made concerning the overall compliance for the lot.

(10) Sample. That portion of an imported lot used to estimate whether or not the lot is acceptable. Samples may at times be further sub-divided into sample units.

(11) Sample Units. A group of units forming a sample which are individually selected, identified and evaluated. A boneless meat reinspection, for example, may require a 72 pound sample consisting of six 12-pound sample units.

(12) **Random Sample.** A sample drawn in such a manner that every unit within the lot has an equal chance of being selected.

* * *

(13) **Lot.** A group of similarly processed/packaged product from one country, one establishment, and consisting entirely of one product code.

(14) **Official Control.** Inspectional restraint or direction without official security.

(15) **Official Security.** Inspectional restraint by use of an official device. (Seal, lock, crosstaped and stamped, etc.)

(16) **Solid Mixed Product.** Includes canned hams and picnics, slab bacon, or other solid single unit type products.

(17) **Tempering.** Removal of frost or ice glaze from surfaces of frozen meat cuts to facilitate product examination.

(b) Canning Definitions

(1) **Buckle.** A permanent distortion of the container end due to excessive internal pressures developing during heat processing.

(2) **Cable cut.** An abrasion of the top of the container double seam caused by the action of moving cable conveyors on stationary cans.

(3) **Determination.** Separation of layers of packaging material that results in the questionable integrity and safety of the product.

(4) **Flexible container.** The shape or contour of the filled, sealed

container generally takes the shape of the enclosed product. The retort pouch is a common example.

(5) **Flipper.** A rigid metal container which normally appears flat, but when brought down sharply on the end of a flat surface, one end will flip out. When pressure is applied to this end, it will flip in again and the can will again appear flat (normal).

(6) **Improper closure seal.** Defects (e.g., entrapped food, grease, moisture, voids, fold-over wrinkles) in that area of the closure seal which extends 1/8 inch vertically from the edge of the seal on the food product side and along the full length of the seal.

(7) **Improper tear notch.** Less than 3/16 inch of defect-free seal from the end of the tear notch to the inner edge of the seal.

(8) **Loose tin.** End or ends of a rigid or semi-rigid container that do not show evidence of full vacuum, thus allowing movement.

(9) **Overfill.** Excess product in a container causing can ends to bulge. Usually identified by determining product net weight.

(10) **Semi-rigid container.** The shape or contour of the filled, sealed container is not affected by the enclosed product under normal atmospheric temperature and pressure, but can be deformed by normal firm finger pressure.

(11) **Springer.** A container (rigid or semi-rigid) with one end permanently bulged. When sufficient pressure is applied to this end, it will flip in, but the other end will flip out.

damage, they shall be handled as outlined in section 27.15(b). The lot from which they were sorted shall be placed on "sample and hold."

Inspectors shall notify U.S. Customs of the sorted product and inform the field compliance office of its location.

27.11 LOTTING; LOT SIZE

Importers will designate on the MP Form 410 how they will present products (lot size) for inspection.

The weight and/or number of containers of similar product from one establishment is the "lot size" which is entered into the computer system to request an Inspection Assignment.

Importers should be encouraged to present the largest possible lots for inspection.

Non-separately identifiable lots presented for inspection shall be combined into a single lot by the inspector.

27.12 SAMPLING; PLANS; SELECTION

Inspections are performed using a variety of statistically sound sampling plans assigned by the Automated Import Information System (AIIS) according to type of product, type of inspection, and lot size.

* Such assignment should be obtained
* from the computer just prior to the
* time of inspection. The purpose of
* this procedure is to assure that the
* assignment reflects the most current
* inspection findings. However, we
* recognize that importers and FSIS
* import inspectors need time to
* manage and plan their schedules
* efficiently. Therefore, it is
* permissible to pull an assignment up
* to 72 hours prior to inspection.
* The 72-hour limit shall start at
* 3:00 p.m. the day the assignment is
* obtained from AIIS. AIIS assignments
* shall be carried out as stated except
* under the following situation:

1. The lot on initial visual *
examination is obviously unaccept- *
able. *

2. Inspection personnel suspect *
the authenticity, wholesomeness or *
integrity of the product. These *
suspicious lots should be discussed *
with circuit supervisors. *

3. Product from the establishment *
has been rejected during the last *
72 hours at that port. In such *
situations subsequent lots shall *
receive normal inspection. *

If the inspection is not performed *
prior to the end of the 72 hour *
period and another assignment must *
be obtained, the most restrictive *
combination of the two assignments *
should be used. *

Sample sizes determined by the
computer system are further identified
as randomly selected sample container
numbers on the Inspection Assignment.

When the Inspection Assignment
requires a two-step sampling plan as in
boneless meat reinspection first step
samples will be stamped once with the
"USDA Official Sample" stamp, and
second step samples will be identified
by stamping twice with this stamp.
Both first and second step samples will
be removed from lots, kept separate,
and be available for inspection as
needed.

Wherever the Inspection Assignment
sample container numbers cannot be
used, or are not available, the
inspector shall select random numbers
from other acceptable sources. The
selected numbers, reason for use, and
their source shall be identified on the
"Inspection Worksheet," MP Form 68.

Prior to sampling, the inspector
shall determine that the lot is
presented in a manner to provide for a
meaningful count that will assure
accuracy in selection of sample
cartons.

During selection of sample containers, obviously defective, damaged, or otherwise suspicious containers shall not be excluded from the sample, or passed over.

Sample containers shall be maintained under the control of the inspector, and where such control is not possible, samples shall be adequately secured.

27.13 PRODUCT EXAMINATIONS; SAMPLE PREPARATION

During sample preparation and product examinations, inspectors must assure that samples are handled in a manner to maintain their wholesomeness and quality, as follows:

a. When inspectors observe questionable defects, detect unusual conditions, or suspect abnormal situations, they shall immediately contact supervision for guidance.

b. Inspectors must assure that samples are under their control or adequately secured during preparation for product examination.

c. Inspectors shall use the sampling plans and defect criteria listed on the reverse side of MP Form 68 for:

1. Boneless manufacturing meats
 2. Condition of container examination (metal, glass, flexible, or semi-rigid)
 3. Canned or packaged product examination (solid mixed product)
- Defect descriptions and classifications for these examinations are on the front of MP Form 68.

d. Inspectors shall use the sampling plans and defect criteria in:

1. Table 27.3 for red meat carcasses, sides, and quarters.

2. Table 27.4 for red meat wholesale cuts (insides, knuckles, hams, loins, etc.). For lamb, mutton, pork, and goat carcasses use Table 27.4 and proceed as follows: Select sample carcasses using random numbers contained in the inspection assignment. The 12-pound sample unit will be an

estimated weight from either the fore, rack, loin, or hind section. The first 12-pound sample unit (section of carcass) will be randomly selected from either the fore, rack, loin or hind section. The second and additional sample units will continue in a rotation pattern. For example, if the starting point selected is the loin section, the sample unit from the next carcass would be a 12-pound sample unit from the hind section, the next sample unit would be from the fore section, etc.

3. Table 27.5 for red meat retail cuts (steaks, chops, roasts, etc.).

4. Table 27.6 for poultry carcasses (chickens, turkeys, etc.)

e. For products not previously or specifically described (i.e., pork feet, extracts of meat, etc.), inspectors shall examine them using acceptance criteria as required by regulations, procedures, or policies for domestic product:

TABLE 27.3

SAMPLING PLANS FOR RED MEAT SIDES(*)

LOT SIZE (IN SIDES)	STEP	SAMPLE SIZE (SIDES)	CRITICAL		MAJOR		TOTAL	
			ACC	REJ	ACC	REJ	ACC	REJ
100	-	3	1	2	4	5	12	13
250	1	4	1	3	3	7	12	17
	2	3	-	-	-	-	-	-
		7	2	3	8	9	24	25
500	1	7	1	5	4	10	18	28
	2	7	-	-	-	-	-	-
		14	4	5	14	15	45	46
500	1	10	1	6	6	13	18	37
	2	12	-	-	-	-	-	-
TOTAL		22	6	7	21	22	68	69

(*) USE CARCASS AQL PROCEDURES (DEFECT DESCRIPTIONS/CLASSIFICATIONS) IN MPI MANUAL, PART II

UNITED STATES DEPARTMENT OF AGRICULTURE
Food Safety and Inspection Service
Meat and Poultry Inspection
Washington, DC 20250

MEAT AND POULTRY INSPECTION REGULATIONS

Date: JULY 1983

MAINTENANCE INSTRUCTIONS

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There are no MPI Regulation changes this month.

**United States
Department of Agriculture**

Washington, D.C.
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